

# Work Order ID 71542

Wednesday, July 06, 2011 11:32:05 AM



Page 1

Item ID:	D4074-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket					
Start Date:	7/6/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	7/20/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/07/06</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D4074	<u>A B</u>	<u>11.07.26</u>

100 NO CHANGES BETWEEN REV. A + REV. B. 0.00

Waterjet Memo 0.00 B11-7-14

FLOW CNC Waterjet 1-Cut as per Dwg  
 6061 .128 Dwg Rev: A  
 Prog Rev: D

2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

QC Memo 0.00 B11-7-14

Quality Control

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 71542**

Wednesday, July 06, 2011 11:32:05 AM



Page 2

Item ID: D4074-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 7/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

S 11/07/11



QC

Memo

0.00

Quality Control

(12)

130

Bend as per dwg

0.00

SB 11/07/11



Brake NC

Memo

0.00

Brake NC

(12)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

M 11 01 21 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 71542

Wednesday, July 06, 2011 11:32:05 AM



Page 3

Item ID: D4074-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 7/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12 0 BR 11-7-20

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 117745

Memo

0.00

Powder Coating

POWDER COAT:

Start Time: 1240

Oven Temperature: 300

Finish Time: 1:10

12 0 BR 11-7-20

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 0 M 11-7-20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 06, 2011 11:32:02 AM

Page 1

Work Order ID: 71542

Parent Item: D4074-1

Parent Item Name: Bracket



Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	84.5514	0.0452	0.570947			



6061-T6 .125 Sheet



B11-7-14

Location

Loc Qty

Loc Code

MAT021

84.55136842

113608

77.17

116700

7.38136842

116700

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

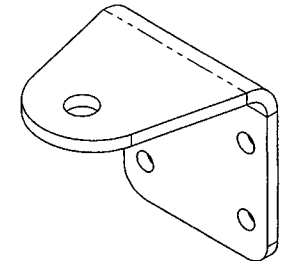
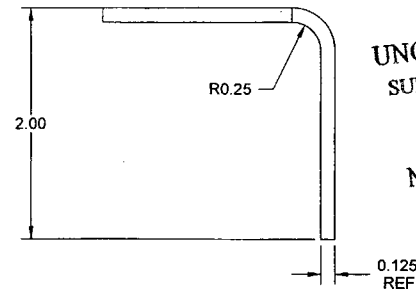
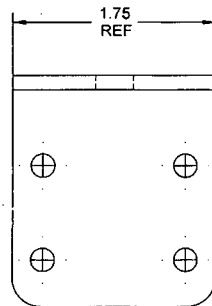
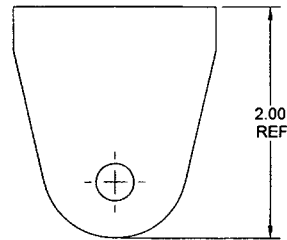
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries







SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 71542  
*CL1107106*

**RELEASED**  
2010-09-23  
*MP*

**D4074-1 BRACKET**  
(MAKE FROM D4074-1F FLAT PATTERN)

**NOTES:**

- 1) MATERIAL: MAKE FROM D4074-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

A		NEW ISSUE		HS		10.09.16	
REV.		DESCRIPTION		BY		DATE	
DESIGN		<b>DART AEROSPACE USA, INC.</b>					
DRAWN	<i>RF</i>	PORT HADLOCK, WA					
CHECKED	<i>MP</i>	DRAWING NO. <b>D4074</b>				REV. A	
MFG. APPR.	<i>MP</i>					SHEET 1 OF 7	
APPROVED	<i>MP</i>	TITLE <b>BRACKET</b>				SCALE	
DE APPR.	<i>MP</i>					NTS	
DATE		10.09.16					

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## Kim Johnston

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**From:** David Shepherd <dshepherd@dartaero.com>  
**Sent:** Friday, July 22, 2011 1:00 PM  
**To:** 'Linda Lacelle'; 'Roberto Fuentes'  
**Cc:** Mike Petsche; 'Kim Johnston'  
**Subject:** RE: Under Review - D4092, D4093, D4153, D4074 and D4131

Linda,

As discussed:

- a) D4092/D4093 should not be manufactured as is
- b) There are changes coming on D4153 and D4131, but it is acceptable to manufacture and release parts that are made per per D4153 Rev A and D4131 Rev A
- c) All D4074-X parts must be manufactured per D4074 Rev B ... There is no change to D4074-1/-5 but changes are required to D4074-3/-7. D4074 Rev B should arrive in Hawkesbury today.

Hope this clarifies the situation ... Sorry for any confusion.

David

---

**From:** Linda Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** July-22-11 7:16 AM  
**To:** 'Roberto Fuentes'  
**Cc:** dshepherd@dartaero.com  
**Subject:** RE: Under Review - D4092, D4093, D4153, D4074 and D4131

I have kits to ship next week, and more the week after, when is 4074, 4153 and 4131 all going to be released??

L

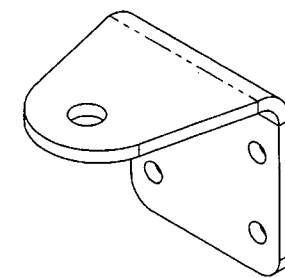
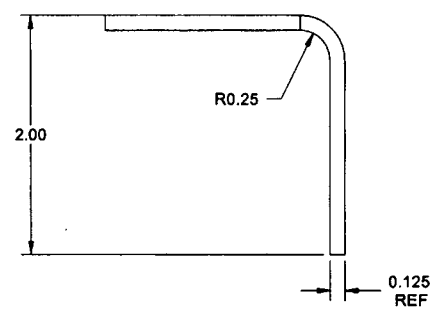
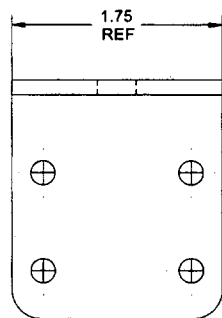
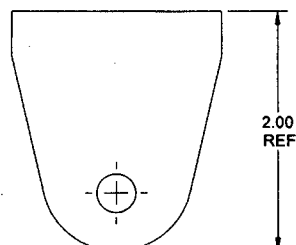
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**From:** Roberto Fuentes [mailto:rfuentes@dartaero.com]  
**Sent:** July 20, 2011 11:45 AM  
**To:** Linda Lacelle  
**Cc:** 'Stocker, Alan'; 'Beckett, Bill'; 'Golden, Brigitte'; 'Lavoie, Chantal'; 'Provencal, Chris'; 'Campbell, Daniel'; 'Duval, David'; 'Shepherd, David'; 'Charbonneau, Eric'; 'Downing, Eric'; 'Siemens, Harvey'; 'Jean-Francois Sauve'; 'Menard, Jean-Luc'; 'Johnston, Kim'; 'Fauteux, Melanie'; 'Petsche, Mike'; 'Willems, Sian'; 'Bedford, Sue'; 'Sheldon, Susanne'; 'Kerr, Cathy'; Marc Bellavance  
**Subject:** Under Review - D4092, D4093, D4153, D4074 and D4131

Hi everyone,

D4092, D4093, D4453, D4074 and D4131 drawings are now under review per attached form.

Thanks,  
Roberto



**D4074-1 BRACKET**  
(MAKE FROM D4074-1F FLAT PATTERN)

**NOTES:**

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

71542

**RELEASED**  
2011-07-25

B	Ø0.173 WAS Ø0.129 (ZN B3-4); 1.28 WAS 0.90 (ZN C4-6); 1.93 WAS 1.55 (ZN C2-7); 2.10 WAS 1.72 (ZN C1-7)	RF	11.03.07
A	NEW ISSUE	HS	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	11.03.07		

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. **D4074** REV. B  
SHEET 1 OF 7

TITLE **BRACKET** SCALE NTS

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